

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024635**Date Inspected:** 08-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Changxing Island **Location:** Shanghai, China**CWI Name:** Sha Zhi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Vikram Singh was present during the times noted above for observations relative to the work being performed at ZPMC.

WELDING

OBG Bay 14

This QA Inspector randomly observed the following work in progress:

Shielded Metal Arc Welding (SMAW)

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3007AD-023 located on Floor Beam to Side Plate at PP119 of the OBG Segment 13AE. The welder is identified as 044772. ZPMC Quality Control (QC) is identified as Mr. Zhang Qiang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair and B-WR20210.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3007L-126 located on Edge Beam to Floor Beam of the OBG Segment 13AE. The welder is identified as 200113. ZPMC Quality Control (QC) is identified as Mr. Zhang Qiang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-1G (1F)-FCM-Repair and B-WR19474.

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This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3007L-129 located on Edge Beam to Floor Beam of the OBG Segment 13AE. The welder is identified as 216086. ZPMC Quality Control (QC) is identified as Mr. Zhang Qiang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-FCM-Repair and B-WR19475.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3007AB-032 located on Edge Beam to Floor Plate of the OBG Segment 13AE. The welder is identified as 037743. ZPMC Quality Control (QC) is identified as Mr. Zhang Qiang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-FCM-Repair and B-WR19314.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3009B-144 located on Floor Beam to Corner assembly of the OBG Segment 13BE. The welder is identified as 067571. ZPMC Quality Control (QC) is identified as Mr. Zhong Yong Gang. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1.

Flux Cored Arc Welding (FCAW)

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as Seg3007AZ-075 located on Floor Beam of the OBG Segment 13AE. The welder is identified as 045024. ZPMC Quality Control (QC) is identified as Mr. Zhang Qiang. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as Seg3009B-006 located on Floor Beam Flange to Deck Panel Diaphragm at PP120.5 of the OBG Segment 13BE. The welder is identified as 066881. ZPMC Quality Control (QC) is identified as Mr. Zhong Yong Gang. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as Seg3009F-006 located on Floor Beam Flange to Deck Panel Diaphragm at PP120.5 of the OBG Segment 13BE. The welder is identified as 067138. ZPMC Quality Control (QC) is identified as Mr. Zhong Yong Gang. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

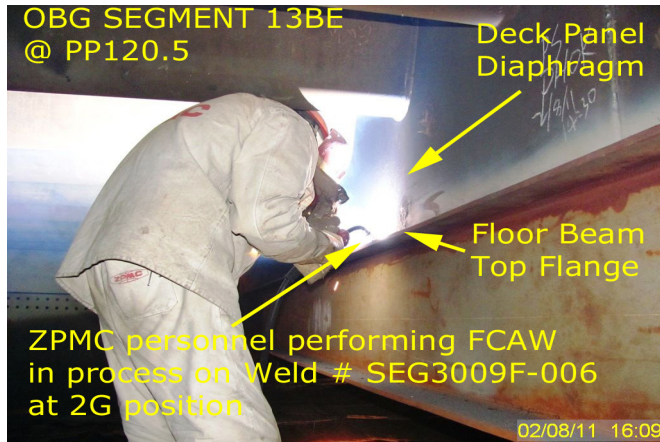
This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as Seg3011B-004 located on Deck Panel Diaphragm to Deck Panel Diaphragm of the OBG Segment 13BE. The welder is identified as 066041. ZPMC Quality Control (QC) is identified as Mr. Zhong Yong Gang. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as Seg3009F-006 located on Floor Beam Flange to Deck Panel Diaphragm at PP120.5 of the OBG Segment 13BE. The welder is identified as 067138. ZPMC Quality Control (QC) is identified as Mr. Zhong Yong Gang. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB. See photo below:

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Singh, Vikram	Quality Assurance Inspector
Reviewed By:	Patterson, Rodney	QA Reviewer
